

19-7799.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C3-12-1

Job Sheet 202228



Part No: C3-12-1

Job Qty: 40 pcs

DAS

Part Name: Lock Bushing



41 pcs - 21 9-88

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/19

Job Tracking No:

Due Date: 11/29/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: C3-12-1 REV.7A IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	40 pcs	11/29/19	11/29/19	1.00	6.67	SL-154 - 1		JB 19-12-14
130	QC 2	40 pcs	11/29/19	11/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 19-12-14
							QC 2 - 63		

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Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Container No: S240287

Part: C3-12-1

Job No: 202228

Serial No/Batch: S240287

Revision: 7A

Inspector:

Exp Date:

Plex 10/22/19 1:58 PM Dart.Renwick.Jennifer

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140 QC 8	40 pcs	11/29/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	L. 19-12-14
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
210 Packaging 3-1 - Stock - B4B	40 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

220 QC 21 - FG 40 pcs 11/29/19 0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

DEC 16 2019

DAS

DAS

DEC 16 2019

Part Op 120 - MORI SL-154 LATHE - 1- Machine as per folio FB753 FOLIO REV: AA DWG REV: 7A 2-

Descriptions: Deburr

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

210 - Identify as per dwg & Stock Location: _____

220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R0.750	17-4 SS H900 Round Bar 0.750"	1.6000 ft (.04 ea)	120-SL-154 - 1	<u>5207798</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	M17-4-H900-R0.750	2	17	0

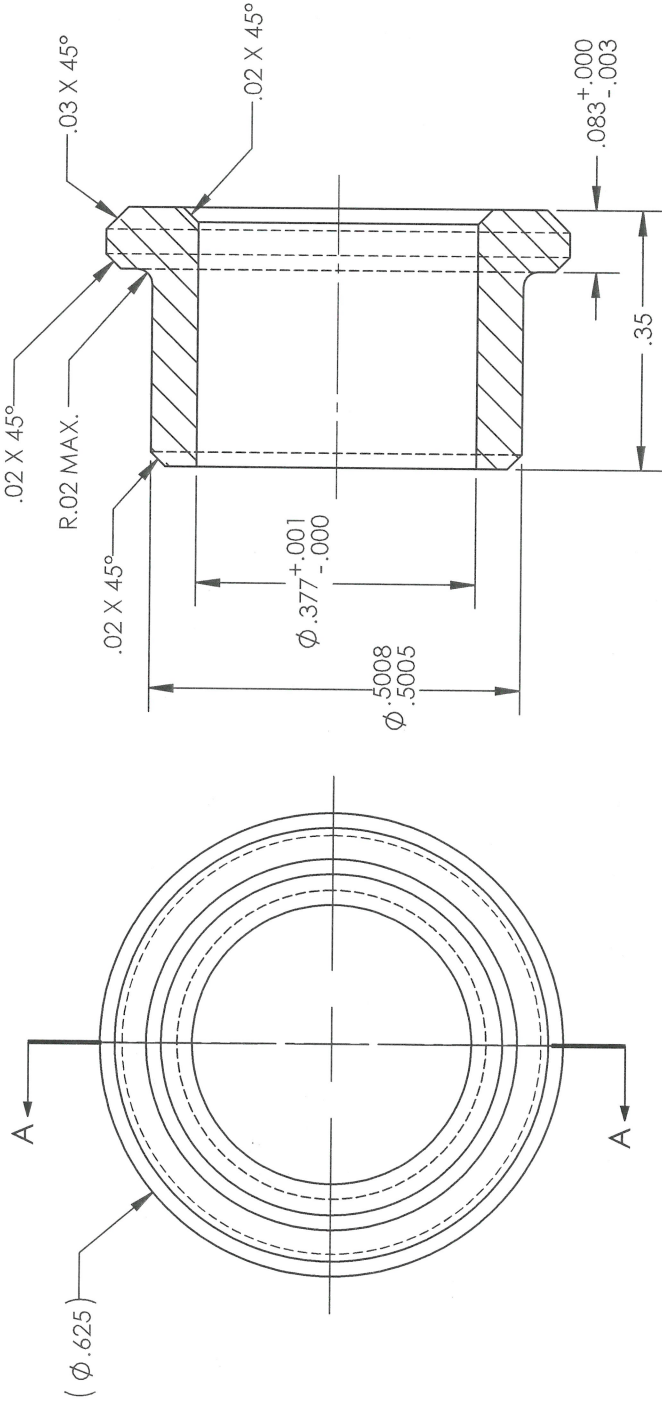
Part Specifications

Specifications could not be found.

Plex 10/22/19 1:58 PM Dart.Renwick.Jennifer

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REVISIONS			
REV	ECR	DESCRIPTION	
6		CHD Ø.499 TO Ø.5008 - .5005	DATE INITIAL APPROVED
7		CHD RADIUS WAS R.015 MAX. IS R.02 MAX. ADDED NOTE 1.	8/15/2012 JAG
7A	14-0111	CHD TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CHD DIMENSION Ø.625 TO REF., CHD DIMENSION WAS .350 IS .35.	8/6/2013 RJC
			8/7/2014 DJN RW



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 202228

SECTION A-A

- NOTES:
1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
 2. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE		TITLE LOCK BUSHING	
DWG NO. C3-12-1		REV 7A	
MATERIAL 4140		DRAWN BY: CANAM	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED RC 44-46	
XXX ± .005		FRACTIONS ± 1/8	
XX ± .01		ANGLES ± .5°	
X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 X 45°		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SHEET 1 OF 1	
SCALE 4:1		DATE 11/2/2001	
B/O INFORMATION OR SPECIFICATIONS		P.G.	
Material 4140		Description LOCK BUSHING	
UNIT QTY		Part # C3-12-1	
ASSY QTY		1	

SEE ATTACHED DEVIATION

DQA: JK Date: Dec 31/19
 QA Closed: 19-7799 Date: 202228



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>202228</u> Part No. <u>C3-12-1 Rev. 7A</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Large Fab ☐ Composite ☐ Supplier ☐		Engineering ☒ Quality ☐ Other ☐																																																																									
Date: <u>19-12-14</u> Step #: <u>120</u>		QTY Effective: <u>41</u>		MRB (Q51042) Approval <u>Mee</u> Oct 11, 2018		Completed By <u>[Signature]</u>																																																																									
Description Work Order Deviation C3-12-1 can be manufactured from 17-4PH-H900 as an alternative material Heat treat and Nickel plating is not required if the part is manufactured from 17-4PH-H900				Disposition - This deviation is acceptable. - The fit, form and function of the part will be as originally intended.																																																																											
Root Cause <table border="1"> <tr> <td>Environment</td> <td>No Re-verification</td> <td>Pressure/Forced</td> <td>Temperature/Cure</td> <td>Power Loss/ Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Design</td> <td>Operator</td> <td>Bending</td> <td>Set-up</td> <td>Folio/Program</td> <td>Outside Dimensions</td> </tr> <tr> <td>Doc/Data</td> <td>Offset/Setup</td> <td>Centre Not Concentric</td> <td>BOM/Route</td> <td>Grain</td> <td>Over/Under tolerance</td> </tr> <tr> <td>Equip/Tooling</td> <td>Supplier</td> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Part Incorrect</td> </tr> <tr> <td>Handling/Pre</td> <td>Training</td> <td>Crimp/Kink/Ripple/Wave</td> <td>Inspection Incomplete/Unqualified</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Material</td> <td>Use for Testing</td> <td>Cuffs</td> <td>Contamination</td> <td>Out of Sequence</td> <td>Part Moved</td> </tr> <tr> <td>Internal Transport</td> <td>Poor Information</td> <td>Crushing</td> <td>Countersink</td> <td>Off-set</td> <td>Drawing</td> </tr> <tr> <td>Tribal Knowledge</td> <td>Rushing</td> <td>Heat Treat</td> <td>Cut Too Short</td> <td>Mislabeled</td> <td>Finish</td> </tr> <tr> <td>LOA</td> <td>Product Improvement</td> <td>Wave/Twist in Tube</td> <td>Instructions Incomplete/Unclear</td> <td>Fit/Function</td> <td>Misread</td> </tr> <tr> <td>Substation</td> <td>Process Improvement</td> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Misaligned/off center</td> <td>Turning Sequence</td> </tr> <tr> <td>Past Expiry Date</td> <td>Manufacturing Process</td> <td colspan="4"></td> </tr> <tr> <td>Misidentified</td> <td>Past Due</td> <td colspan="4"></td> </tr> </table>				Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/ Surge	Positioned Wrong	Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions	Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect	Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing	Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved	Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing	Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish	LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread	Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence	Past Expiry Date	Manufacturing Process					Misidentified	Past Due					QC / QA Coordinator Approval <u>DAS</u> <u>9</u> <u>9-89 19-12-19</u>			
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